

Work Order ID 127616

December-17-14 1:40:33 PM

127616

Page 1

Item ID: D3167-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 12/17/14

Start Qty: 3.00

3

Cust Item ID:

Required Date: 12/17/14

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-12-23

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3167

Rev A1

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D3167-1_BLANK

UHMW 1"

6 0 Jm 15-1-23

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA285 and Dwg D3167

3-Deburr

6 0 BG JFC 15-2-3

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

6 0 BG JFC 15-2-3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127616

127616

Page 2

December-17-14 1:40:33 PM

Item ID: D3167-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 12/17/14 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							DAS 08 9-89
Quality Control									

151	Identify as per dwg & Stock Location: <i>fk</i>	0.00							
151									
Packaging	Memo	0.00							
Packaging									

190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

15.2-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

December-17-14 1:40:33 PM

Page 1

Work Order ID: 127616

127616

Parent Item: D3167-1

D3167-1

Parent Item Name: Bearpaw

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 3.00

Required Qty: 3.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10

Purchased

No

120

sf

39.0000

3.6

~~10.8~~

MUHMWB10

20

Jm 15-1-23

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT018

39

m128092

39

131335

131335

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	127616
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	.06	✓		6" Vern	ED 6
B	5.80	+/-0.030	5.80	✓		"	"
C	0.25 x 45°	+/-0.030	.250	✓		"	"
D	R0.25	+/-0.030	.250	✓		"	"
E	0.200	+/-0.030	.196	✓		"	"
F	0.250	+/-0.010	.260	✓		"	"
G	0.625	+/-0.030	.634	✓		"	"
H	0.375	+/-0.010	.385	✓		"	"
I	0.950	+0.030/-0.010	.960	✓		"	"
J	3.21	+/-0.030	3.21	✓		"	"
K	19.00	+/-0.030	19.00	✓		Tape	IL 8
L	Ø0.260	+0.005/-0.000	.261	✓		Vern	ED 6
M	Ø0.93	+/-0.030	.930	✓		"	"
N	0.30	+0.030/-0.000	.300	✓		"	"
O	0.375	+/-0.030	.378	✓		"	"
P	7.23	+/-0.030	7.23	✓		Tape	IL 8
Q	4.54	+/-0.010	4.545	✓		Vern	ED 6
R	2.00	+/-0.030	1.995	✓		"	"
S	12.000	+/-0.010	12.00	✓		Tape	IL 8
T	6.000	+/-0.010	6.000	✓		Vern	ED 6
U	23.75	+/-0.030	23.75	✓		Tape	IL 8

Measured by:	36
Date:	15-02-03

Audited by:	M.A. DAS 08
Date:	15/02/03 9-89

Prototype Approval:	N/A
Date:	N/A

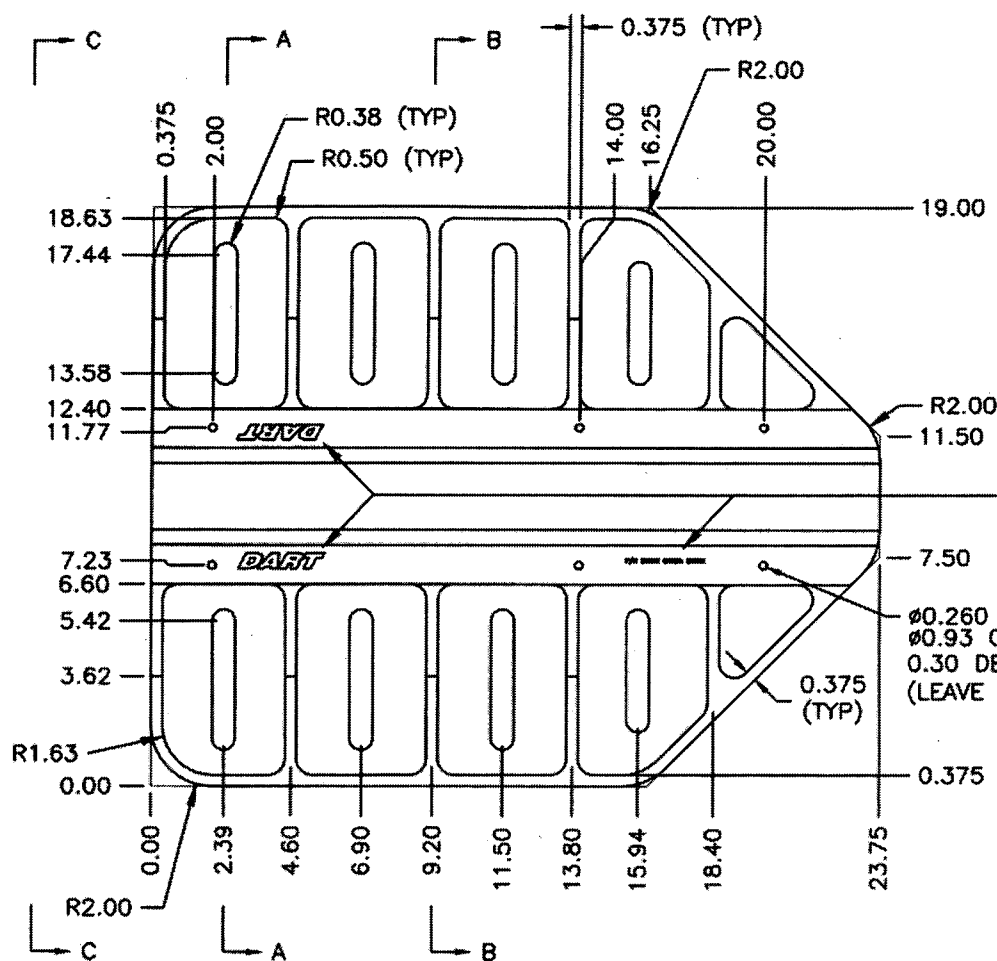
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

EX-100

 DESIGNER		 CHECKING ENGINEER		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167		REV. A SHEET 1 OF 2	
DATE 02.10.08		TITLE BEARPAW		SCALE 1:6	
A	02.10.08	NEW ISSUE		02.12.17 	
A1	02.12.17	5:80 WAS 5:50			

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOT COPY
 RETURNED
 1-10-70
 ONCE COPY
 SMALL COPY
 1-10-70
 127616-ML5
 14-12-23



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

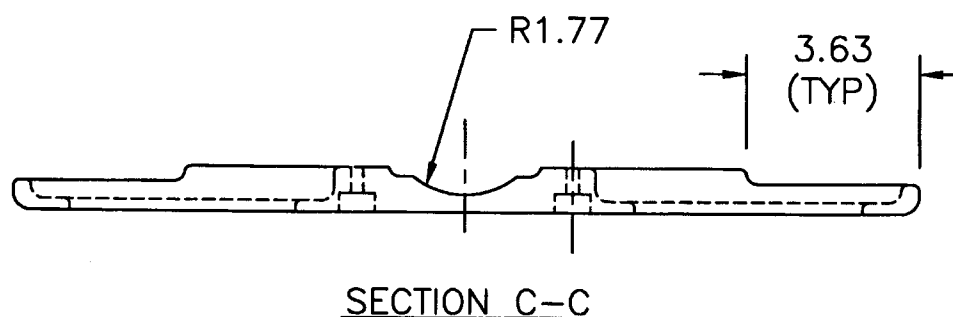
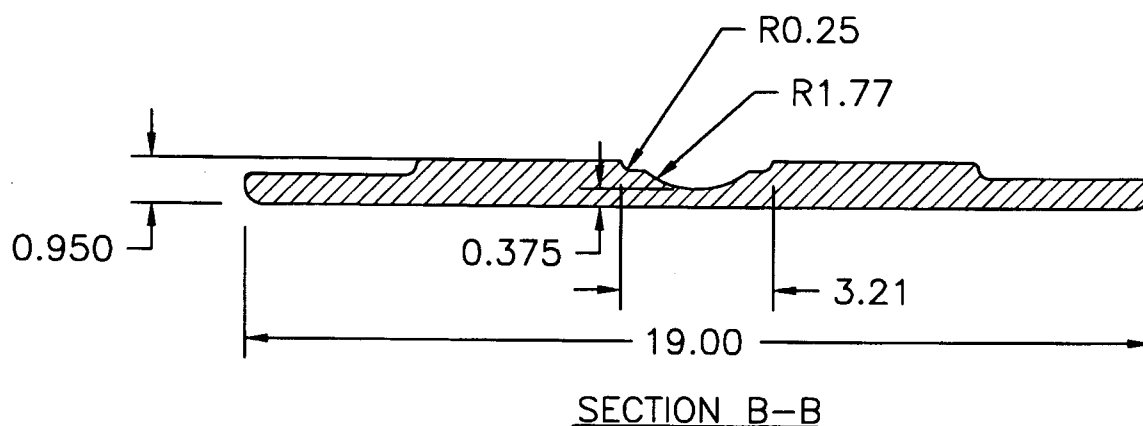
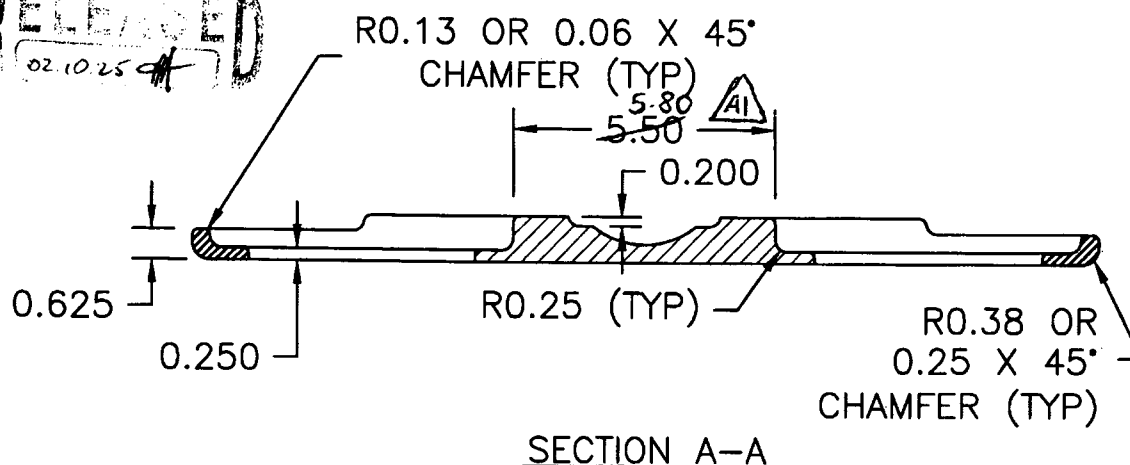
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

RELEASED
02.10.25



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